

A1

1.25 x 1.25

Work Order ID 75977***75977***

Page 1

November-02-11 10:48:44 AM

Item ID: D3299-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 02/11/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 11/10/10 Tooling:

Date:

Run Start ***NR1***

QC:

Date: 11/11

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3299

C

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA901 and Dwg D3299

FOLIO REV: EDWG REV: 11/2/11

DEBURR

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/2/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-02-11 10:48:48 AM

Parent Item Name: Fitting

Component Item ID/ Item Name	Replacement Item ID
---------------------------------	------------------------

M6061T6B1.250X01.25

*M6061T6B1 25

6061-T6 Bar 1.25 x 1.25

November-02-11 10:48:44 AM

Revision ID:

Item Name: Fitting

Start Date: 02/11/2011 **Start Qty:** 8.00

Required Date: 16/11/2011 **Req'd Qty:** 8.00

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

[illegible]

W/O:		
DATE	STEP	

Part No: _____

Resolution: _____

NCR:		
DATE	STEP	Des

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 75977
Description: Fitting		Part Number: D3299-7
Inspection Dwg: D3299	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.248	/			
Ø1.63	+/-0.030	Ø1.626	/			
Ø0.302	+0.005/-0.000	Ø.304	/			
1.08	+/-0.030	1.08	/			
0.04 X 45°	+/-0.030 x +/-0.5°	04x45°	/			
1/4-NPT	N/A		/			
0.550	+/-0.010	.550	/			
1.00	+/-0.030	1.006	/			
2.19	+/-0.030	2.156	/			
0.640	+/-0.010	.641	/			
53°	+/-0.5°	53°	/			
Ø0.650	+0.000/-0.005	Ø.648	/			
Ø0.391	+0.006/-0.001	Ø.394	/			
3/4"-16 UNF-3A	N/A		/			
0.25	+/-0.030	.25	/			
0.10	+/-0.030	.130	/			
Ø0.482	+/-0.010	Ø.480	/			
Ø0.540	+/-0.010	Ø.540	/			
0.118	+/-0.010	.118	/			

Measured by: SA	Audited by: RQ	Prototype Approval:	N/A
Date: 11/2/1	Date: 11-12-4	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

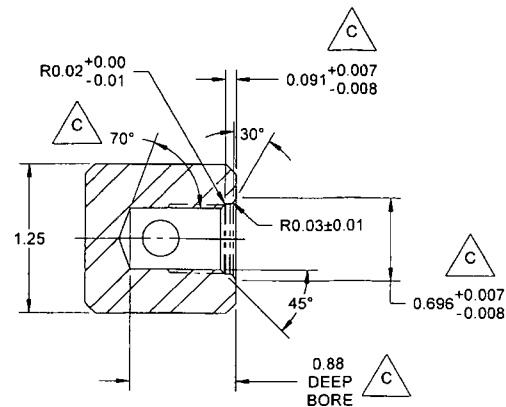
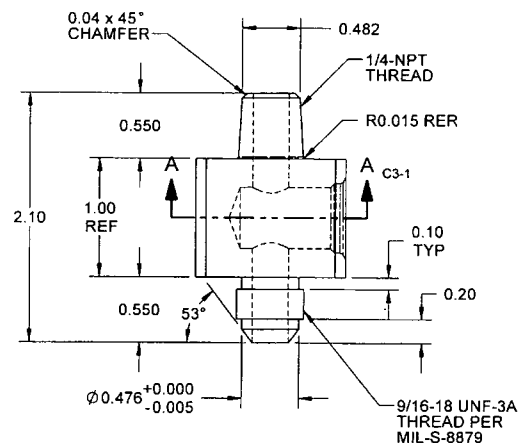
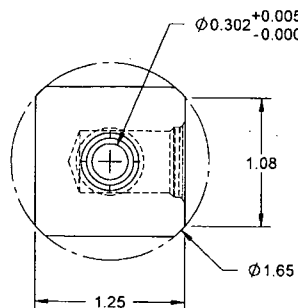
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

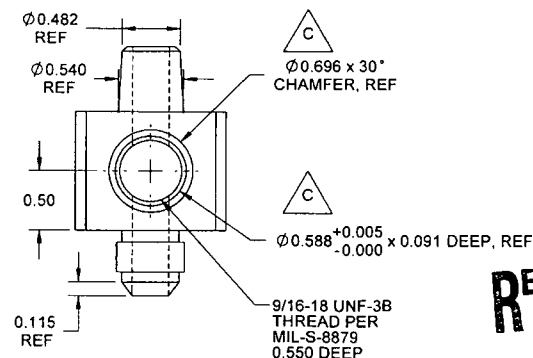
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 75977 M.C.J

11/11/02



SECTION A-A C5-1



RELEASED
2010-01-14
MWO

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2

POSSIBLE SUPPLIER: ANODIZING TNM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-1" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.42 lbs

D3299-1 FITTING

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISE MATERIAL BAR WAS HEX BAR (ZN A8-1); ADD -7 (ZN A4-4); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN D2-1, D3-1, C2-1, B2-1, D5-4, C4-4, B4-4, C1-4) PER CAR 09-004	RF	09.12.30
B	1.09 WAS 0.837; $\phi 302$ WAS $\phi 297$	RF	05.04.28
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3299	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

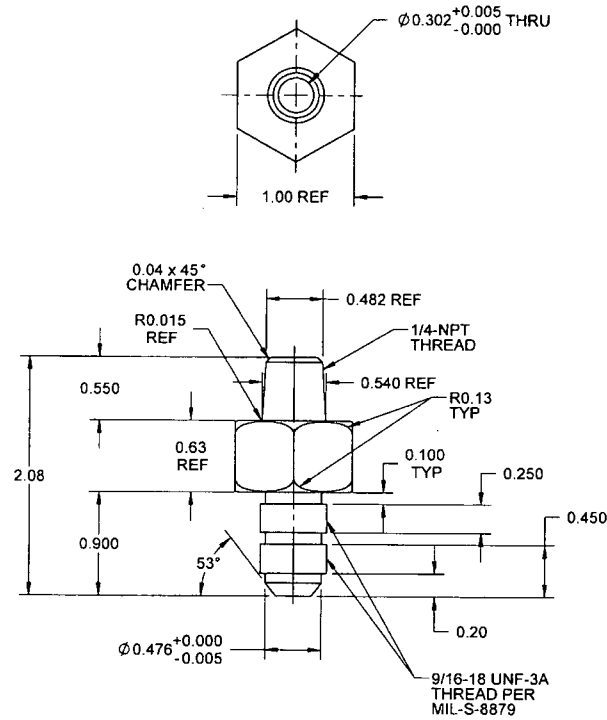
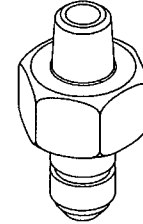
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75977



D3299-3 FITTING

RELEASED
2010-01-14

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.00" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.000

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-3" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.20 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

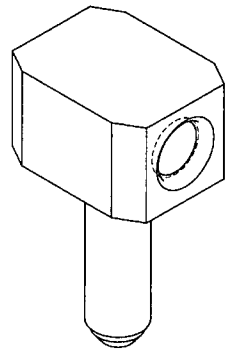
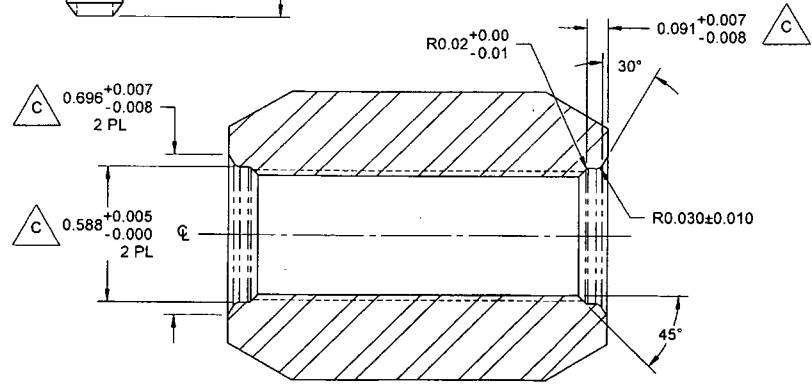
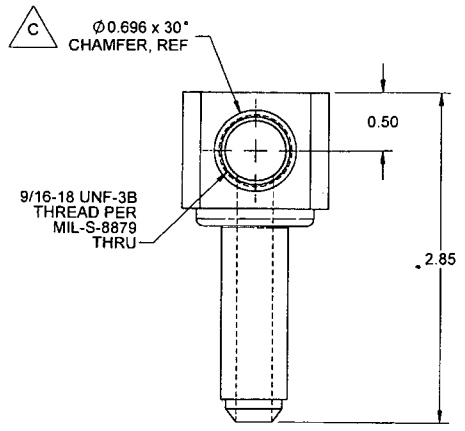
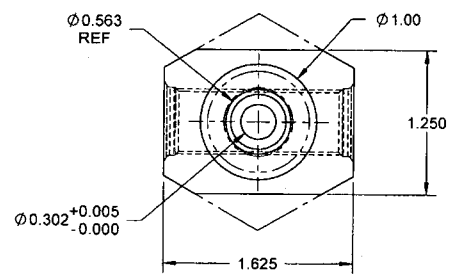
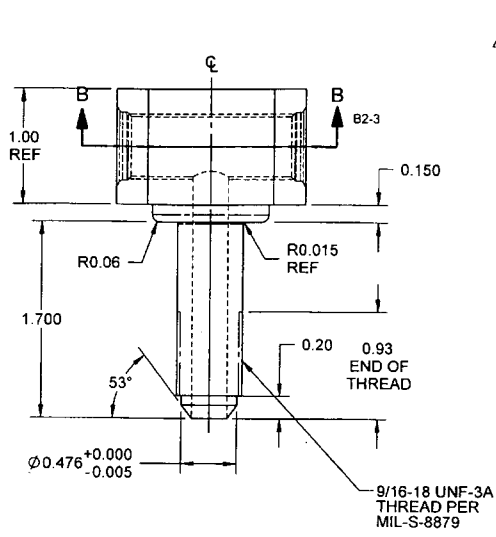
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75977



D3299-5 FITTING

SECTION B-B D6-3
SCALE 2X

RELEASED
2010-01-14

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625
 - 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-5" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.57 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

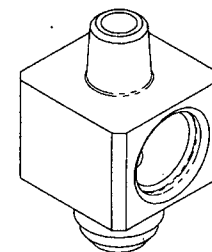
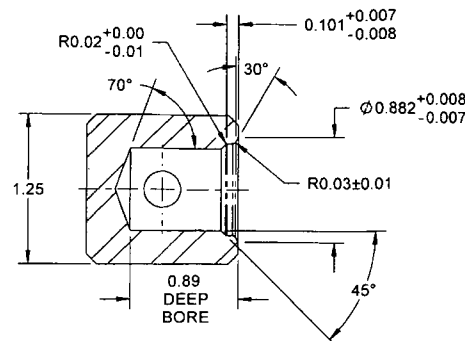
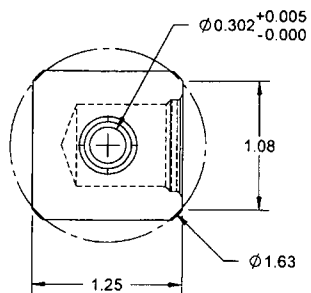
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

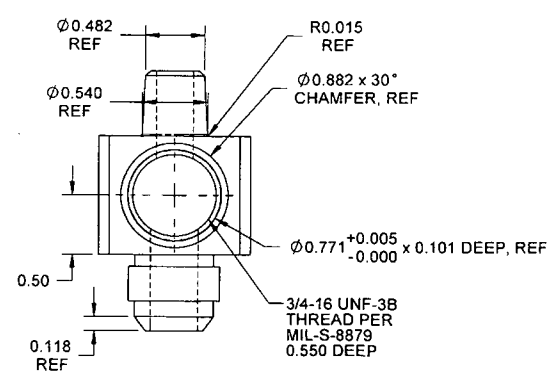
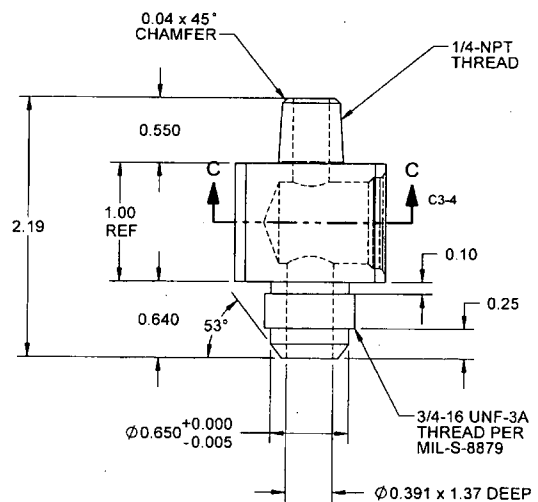
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75977



SECTION C-C C5-4



C
D3299-7 FITTING

RELEASED
2010-01-16
JMB

- NOTES:
- MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6081T6B
 - FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-7" & B/N USING FINE POINT PERMANENT INK MARKER
 - WEIGHT: 0.40 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. . .	REV. C
MFG. APPR.	RF	D3299	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613-632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15786

Purchase Order Date 1/04/12

PO Print Date 1/09/12

Page Number 1 of 2

Order From :

VC-ROY003

ROYAL BANK VISA

X

X, X

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

COD

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	75978	D3299-3 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				
2	75979	D3299-5 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				
3	75977	D3299-7 FITTING	1/13/12 Yes	8.00	FedEx PI collect	\$3.9580	\$31.66
Special Inst:							
			Per MIL-A-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 blue anodize				

PO Instructions: VERDUN ANODIZING (ATTN: MARC FOURNIER)
VISA ACCT: 4516 0500 0053 0448 EXP: 0514 CID: 327

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 1/09/12



Anodisation Verdun Inc.

Verdun Anodizing Inc.

3971, ave Verdun, Verdun (Quebec) H4G 1L1

AS 9100:2004

ISO 9001:2000

Certified

info@verdunanodizing.com

Tel: (514) 761-4531

Fax: (514) 769-4731

PACKING SLIP

DARTAERO

DARTAERO

C
U
S
T
O
M
E
R

DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

S
H
I
P

T
O

DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

[C]

Customer Copy

Attn: CHANTAL LAVOIE 1-613-632-9577 Fax: (613)-632-1053

Customer Order No.	Order Date	Ship Via	No. of Packages	Date Shipped	Reference No.
PO15786	05/01/12	FEDEX	1	09/01/12	273222-00

MIL221BL

Bleu Sulfuric Anodize: DIW S Rev: F1

Item No.	Part No.	Description	Serial No.	Length	Quantities	
					Processed	Not processed
001	D3299-3	MAT:			8.0	
	LINE: 1 FITTING REF: 75978					
002	D3299-5	MAT:			8.0	
	LINE: 2 FITTING REF: 75979					
003	D3299-7	MAT:			8.0	
	LINE: 3 FITTING REF: 75977					

Total: 24.0 0.0

Remarks:

Customer signature



Anodisation Verdun Inc.
Verdun Anodizing Inc.
3971, ave Verdun, Verdun (Quebec) H4G 1L1

AS 9100:2004
ISO 9001:2000
Certified

info@verdunanodizing.com
Tel: (514) 761-4531
Fax: (514) 769-4731

CERTIFICATE OF SUB-CONTRACTOR

DARTAERO

DARTAERO

C
U
S
T
O
M
E
R

DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

S
H
I
P

T
O

DART AEROSPACE LTD.
1270, ABERDEEN STREET

HAWKESBURY
Ontario K6A 1K7

Customer Order No.	Order Date	Process Date	Certificate No.
PO15786	05/01/12	09/01/12	273222-00

PROCESS: MIL A-8625F1 Ty II C1 2 BLEU DIW Seal

Item No.	Quantity	Description	Serial #
001	8.0	D3299-3 LINE:1 FITTING REF:75978 MAT:	
002	8.0	D3299-5 LINE:2 FITTING REF.75979 MAT:	
003	8.0	D3299-7 LINE:3 FITTING REF.75977 MAT:	

We hereby certify that the parts described above and furnished by DART AEROSPACE LTD. have been treated in accordance with the relevant specifications and that no substitution of materials has been made.


Inspector: Verdun Anodizing Inc.